Date User: Tuesday, 12/20/2005 9:48:54 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 23136B

Estimate Number

: 11274

P.O. Number

: N/A

This Issue

Prsht Rev.

: 12/20/2005 : NC

: N/A

S.O. No. : N/A

: NIA

Type

: LARGE FAB ASSY

Part Number

Drawing Name

: D2252043

: N/A

Drawing Number

. UNDER REVIEW

: 206L BASKET LID

Project Number Drawing Revision

: E

Material Due Date

:N/A : 1/30/2006

Qty:

Each 1 Um:

Written By Checked & Approved By

Comment

First Issue

Previous Run

:SER COMMENT BELOW (OMMENT

: Est Rev:I REVISED AS PER REV E 05-12-06 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304 SQ Tube.75x.75x.065W

1.0 M304TS0750W065

Comment: Qty.: 32.5539 f(s)/Unit Total:

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

32.5539 f(s) Batch: <u>M 1944</u>7

LARGE FABRICATION RESOURCE 1

2.0

LARGE FAB 1

Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

Label Plate

3.0

D2329

Comment: Qty.:

1.0000 Each(s)/Unit Total:

1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2329

Label Plate

4.0

D23271

Spacer Bushing



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

1.0000 Each(s)

Pick:

Qty Part Number

Batch

1 D2327-1

Description

Bushing

Dart Aerospace Ltd

W/O:			WORK OR	DER CHANG	GES				
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						· · · · · · · · · · · · · · · · · · ·			
Part No) :	PAR #:	Fault Category:		NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ___

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
		•								

NOTE: Date & initial all entries

Date: User:

Tuesday, 12/20/2005 9:48:55 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Description:

Job Number: 23136B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Hinae

5.0

D22321



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Qty Part Number 2 D2232-1

Description HINGE

6.0

D2581



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chanel

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.:

18.9000 sf(s)/Unit Total:

18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch 18 sf M304EX0.75-16F Expanded Metal M19149

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

SS ROD A/R

Batch: M 19174

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION



10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



06 OI ZZ

06-01-20

W/O:	,	WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector		

2. ¹⁸									

Part No:	PAR #:	_ Fault Category:	 NCR: Yes No	DQA:	Date: <u>(%)</u> (23
			QA: N/C C	losed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annaval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
	-									
						3				

NOTE: Date & initial all entries

Date: User:

Tuesday, 12/20/2005 9:48:55 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 23136B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1

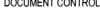


13.0



DOCUMENT CONTROL







Comment: DOCUMENT CONTROL

Inspection Level 21

Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 6 A

Sur 06/01/20



06/01/23

Job Completion



Dart /	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	PROCEDURE CHANGE By Da	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector
•				-			
\$Pa_******			,				
Part No		PAR #: Pault Category: NC	R: Yes	No DQ .	A:	Date: _	

QA: N/C Closed: ____ Date: _

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification A	Ammouel	Ammourel			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
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NOTE: Date & initial all entries